

Work Order ID 73095

Thursday, August 25, 2011 1:27:46 PM



Page 1

Item ID: D3302-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 8/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: mk

Date: 11-08-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3302

Rev B2

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3302

☐ Dwg Rev: B2

☐ Prog Rev: B2

☐ 2-

Deburr if necessary

6061 .063

B11-8-31

(7)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-31

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S u l o s / 31

(x7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

NA

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3302

SB 11/09/10

(7)

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 11/09/10

(77)

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Item Name: Doubler

Start Date: 8/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

TX S M 11/09/12

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

I S M 11/09/12

180

Identify as per dwg & Stock Location: ST 143

0.00



Packaging

Memo

0.00

Packaging

(TX) 11-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, August 25, 2011 1:27:43 PM

Page 1

Work Order ID: 73095



Parent Item: D3302-3



Parent Item Name: Doubler

Start Date: 8/25/2011

Required Date: 9/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP ☐ A ☐ 04.09.02 ☐ New issue ☐ KJ/JLM ☐
IPP ☐ B ☐ 06.05.02 ☐ Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	283.1256	0.9931	6.272211	44.		
6061-T6 .063 Sheet										13-11-8-31			

Location

Loc Qty

Loc Code

MAT021

283.1255684

116308

26.9755684

117285

111.15

118580

145

118580

7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73090
Description: Doubler		Part Number: D3302-3
Inspection Dwg: D3302	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14.452	✓		T H01	
12.75	+/-0.030	12.75	✓		T	
0.851	+/-0.010	0.855	✗		V H02	
0.851	+/-0.010	0.854	2		V	
8.952	+/-0.010	8.959	✓		P Row 302	
R0.12	+/-0.030	0.12	✗		R.G.	
7.250	+/-0.010	7.250	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-8-31	Date: 11/08/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
C	07.01.16	Dimensions revised	KJ/JLM	
D	07.01.29	Dimensions revised	KJ/JLM	

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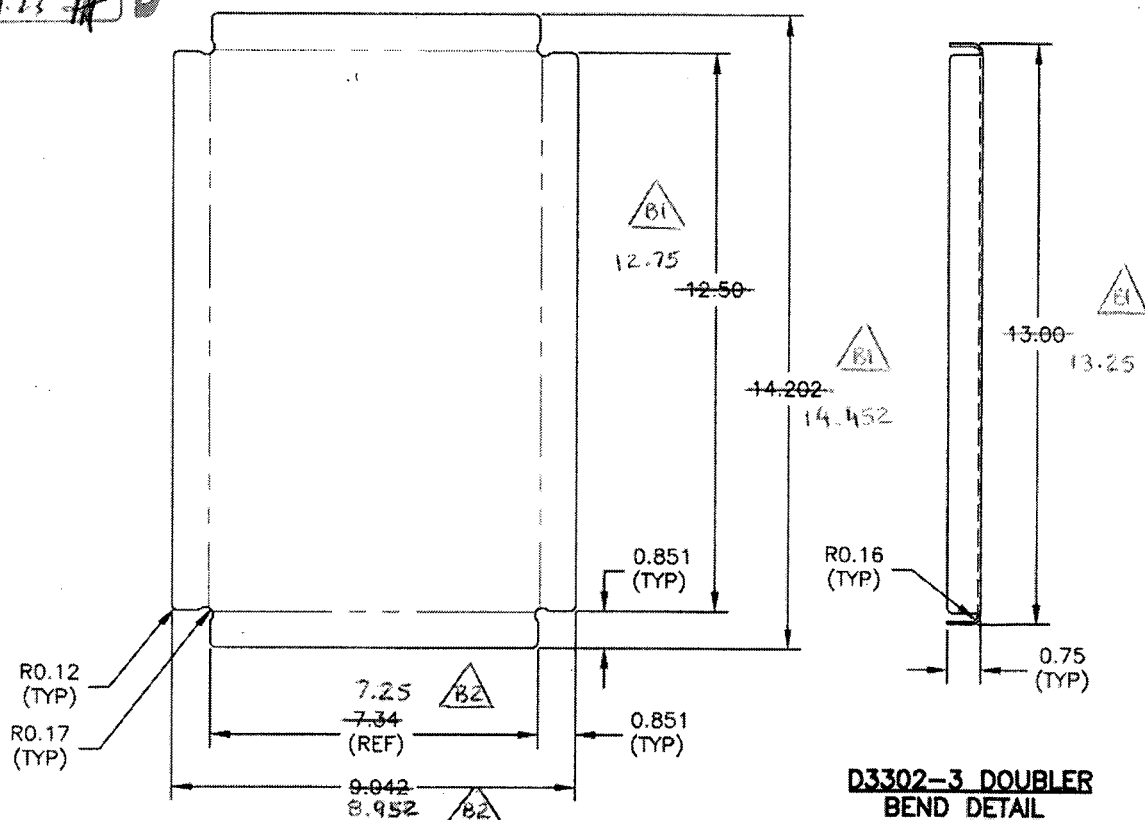
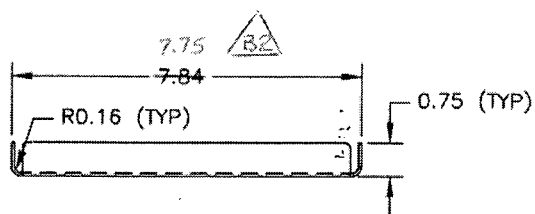
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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 #**D3302-3 FLAT PATTERN****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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